



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4021-9
Job Sheet 173422



Part No: D4021-9

Job Qty: 80 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Due Date: 3/7/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B SHEET 3 IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP Rev:B as per dwg REV.A
DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea	3/6/18	3/6/18	0.00	0.00	Start Up Machining-2		UHB JB 18-03-21
100	Hardinge	80 pcs	3/7/18	3/7/18	0.00	4.35	Hardinge		UHB JB 18-03-21
120	QC	80 pcs	3/7/18	3/7/18	0.00	0.00	QC8		9/2/18/03/21
130	Packaging	80 pcs	3/7/18	3/7/18	0.00	0.00	Packaging3-2		2/1/18-3-22
140	QC21-SA	80 Ea	3/7/18	3/7/18	0.00	0.00	QC21		

Part Op **100** - TURN AS PER FOLIO FA 868 AND DWG D4021 DWG REV: _____ FOLIO REV: _____
Descriptions: ***MACHINE TO .375" MAX OD ***
130 - LOCATION: WA004

MAR 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.375	304 Round Bar 0.375	6.6400 ft (.083 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R0.375	7	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
2	Bushing	0.380Inches ± 0.030	0.410 0.350		
3	Bushing	0.750Inches ± 0.030	0.780 0.720		

Plex 3/1/18 2:00 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;"></td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		Supplier ☐																												
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		Completed By																																										
		Lead hand / Supervisor Approval Verification																																										
		QC / QA Coordinator Approval																																										
Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K8A 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Container No: S053420 Part: D4021-9 Job No: 173422 Serial No/Batch: S053420 Revision: _____ Inspector: _____ Date: 03/21/18																																												
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border: none;"> <tr> <td style="border: none;">Deming ☐</td> <td style="border: none;">BOM/Route ☐</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Centre Not Concentric ☐</td> <td style="border: none;">Broken/Damage/Defect ☐</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Inspection Incomplete/Unqualified ☐</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;"></td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;"></td> <td style="border: none;"></td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>			Deming ☐	BOM/Route ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Centre Not Concentric ☐	Broken/Damage/Defect ☐	Folio/Program ☐	Outside Dimensions ☐	Cracks ☐	Inspection Incomplete/Unqualified ☐	Grain ☐	Over/Under tolerance ☐	Crimp/Kink/Ripple/Wave ☐	Contamination ☐	Weld ☐	Part Incorrect ☐	Cuffs ☐	Countersink ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Crushing ☐	Cut Too Short ☐	Out of Sequence ☐	Part Moved ☐	Heat Treat ☐	Instructions Incomplete/Unclear ☐	Off-set ☐	Drawing ☐	Wave/Twist in Tube ☐	Drill Holes ☐	Mislabeled ☐	Finish ☐	Marks/Chatter ☐		Fit/Function ☐	Misread ☐			Misaligned/off center ☐	Turning Sequence ☐
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